

Work Order ID 55167

January 8, 2010 9:06:05 AM

Page 1

Item ID: D2327-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer Bushing

Date: 08/01/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 14/01/2010 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-1-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2327

Rev D

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

10/01/18

20

Hardinge CNC Lathe Small

Turn per Folio FA232 and Dwg D2327 Deburr

110

0.00



QC2- Inspect parts off machine FA1/FA1B

QC

Memo

0.00

10/01/18

20

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

B.A 10/01/18

20

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/19

MF 10-1-19

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Picklist Print

January 8, 2010 9:06:11 AM

Page 1

Work Order ID: 55167

Parent Item: D2327-3

Parent Item Name: Spacer Bushing

Comments: IPP F005.11.02 Removed 303 SSKJ/ECL

Start Date: 08/01/2010

Required Date: 14/01/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304R0.375

Purchased

No

100

f

60.0851

3.2905



304 ROUND BAR 0.375

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

60.0850579

112058

0.01317895

112473

11.6003

- 113325

48.4715789

3.2 SIA 10/01/18

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55147
Description: Spacer Bushing		Part Number:	D2327-3
Inspection Dwg: D2327 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	SA	Audited by:	H, A	Prototype Approval:	N/A
Date:	10/01/18	Date:	10/01/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	

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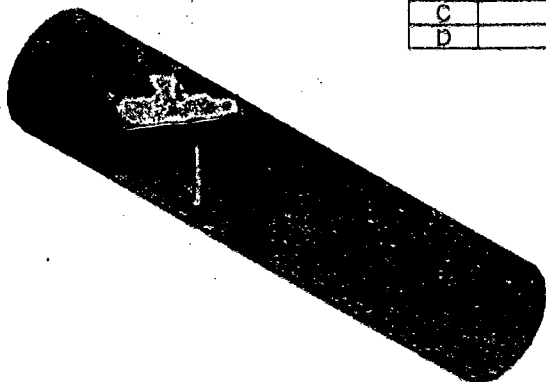
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NOTE: Date & initial all entries



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.05	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

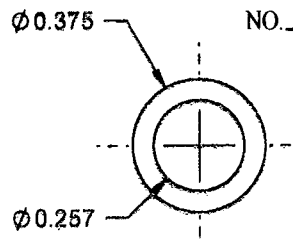
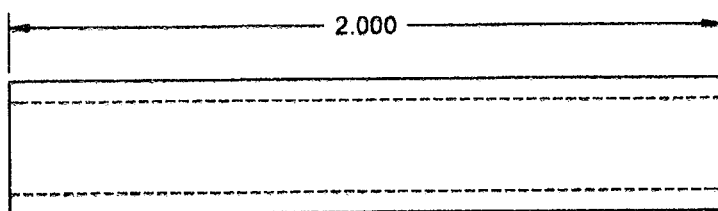


RELEASED

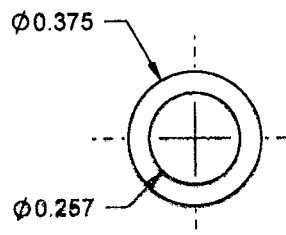
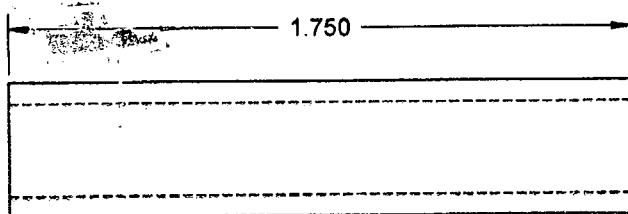
06.11.14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55167

BS10-1-08



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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